

Recd Jan 29th
test

Dart Aerospace Ltd.

Date: Thursday, 11/01/2007 2:31:38 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 30245	
Estimate Number : 12588	
P.O. Number : <i>N/A</i>	Part Number : D35481
This Issue : 11/01/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3548 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 18/01/2007 Qty: 40 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 06-11-13 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.1050 sf(s)/Unit Total : 4.2000 sf(s)

6061-t6 aluminum sheet ~~0.080 Sheet~~ 0.125 sheet

X Batch: *m18666* *m1 07.01.26*

(40)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3548

Dwg Rev: *A*

Prog Rev: *A*

m1 07.01.26

(40)

2-Deburr if necessary

SB 07/02/06

40

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

m1 07.01.26

(40)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SB 07/01/29

(40)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D3548

SB 07/02/06

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: De Date: 07/02/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/01/2007 2:31:38 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 30245

Part Number: D35481

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/02/06 (40)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

22/1/07

07/02/06

(40)

8.0

POWDER COATING

POWDER COATING



M103141



(40x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-A/07

07/02/08

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/02/08 (40)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

04/02/09 (40)

CU

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/12 (40)

Job Completion



U 07.02.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

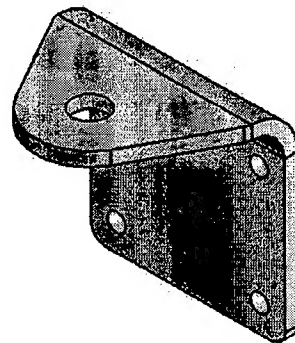
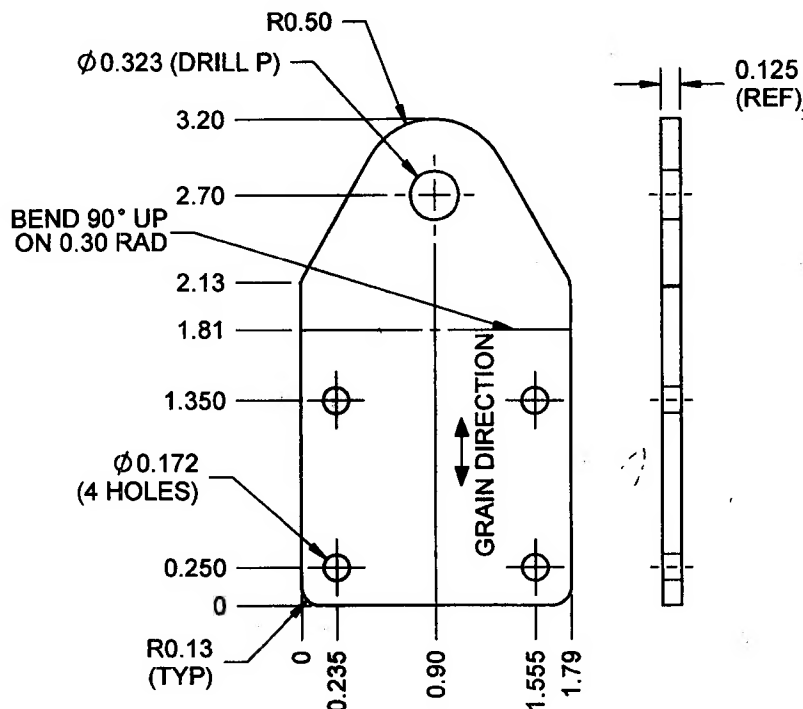
QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

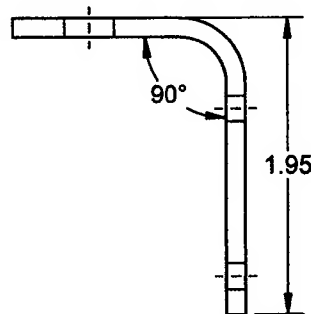
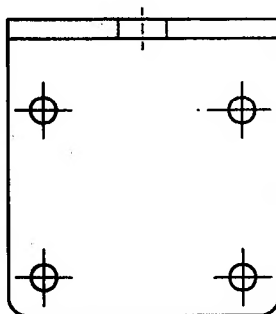


DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3548	REV. A SHEET 1 OF 1
DATE 06.10.06	TITLE BRACKET	SCALE 1:1	
REV A	DATE 06.10.06	DESCRIPTION NEW ISSUE	



RELEASED
06.10.13

D3548-1F FLAT PATTERN



D3548-1 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3548-1 USING FINE POINT PERMANENT MARKER

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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DART-AEROSPACE LTD		Work Order: 30245
Description: Bracket		Part Number: D3548-1
Inspection Dwg: D3548 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.323	+0.006-0.001	0.323	✓		vern	
Ø 0.172	+0.005-0.001	0.172	✓		vern	
1.79	+/- 0.030	1.79	✓		vern	
3.20	+/- 0.030	3.20	✓		vern	
0.250	+/- 0.010	0.250	✓		vern	
0.235	+/- 0.010	0.235	✓		vern	
1.350	+/- 0.010	1.350	✓		vern	
1.555	+/- 0.010	1.555	✓		vern	
2.70	+/- 0.030	2.698	✓		vern	
2.13	+/- 0.030	2.13	✓		vern	
R0.13	+/- 0.030	R0.13	✓		Radius Gauge	

Measured by: M.M	Audited by: AA	Prototype Approval:
Date: 07/01/26	Date: 07/01/29	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

